

Date: Monday, 12/05/2008 9:59:54 AM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: DOUBLER ASSEMBLY
Job Number	: 39186		
Estimate Number	: 10786		
P.O. Number	:	Part Number	: D3151041
This Issue	: 12/05/2008 S.O. No. :	Drawing Number	: D3151 REV B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: // Type : SMALL /MED FAB	Drawing Revision	: B
Previous Run	: 24685	Material	:
Written By	:	Due Date	: 30/05/2008
Checked & Approved By	: <u>JLP 08-5-12</u>	Qty:	6 Um: Each
Comment	: Est A 04.12.01 New issue KJ/JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	39186A	DOUBLER ASSEMBLY
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Comment: Sub-Component DOUBLER ASSEMBLY
 D3151-1 B 39186A

CB 08/05/20 (6)

2.0	39186B	DOUBLER ASSEMBLY
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Comment: Sub-Component DOUBLER ASSEMBLY
 D3151-3 B 39186B

CB 08/05/20 (6)

3.0	D31511	Bracket Flat Pattern
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)
 BRACKET FLAT PATTERN

Pick:

Qty	Part Number	Description	Batch
1	D3151-1	Spacer	B <u>39186A</u>

CB 08/05/20

4.0	D31513	BRACKET
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)
 BRACKET

Pick:

Qty	Part Number	Description	Batch
1	D3151-3	Bracket	B <u>39188B</u>

CB 08/05/20

5.0	MS20426AD33	Rivet
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Comment: Qty.: 6.0000 Each(s)/Unit Total : 24.0000 Each(s)
 Rivet
 Pick:

D

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 12/05/2008 9:59:54 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOUBLER ASSEMBLY

Job Number: 39186

Part Number: D3151041

Job Number:



Seq. #:

Machine Or Operation:

Description :

Qty	Part Number	Description	Batch
6	MS20426AD3-3	Rivet	M1563

EB08/05/20

6.0 MS20426AD34 RIVET



Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)

RIVET

Pick:

Qty	Part Number	Description	Batch
4	MS20426AD3-4	Rivet	M10597.8

EB08/05/20

7.0 MS21059L08 Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Nut

Pick:

Qty	Part Number	Description	Batch
2	MS21059L08Nut	Plate	M12706

EB08/05/20

8.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
Assemble as per Dwg D3065 and Identify as D3065-041

EB08/05/20 (6)

9.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8 08/05/20 (46)

10.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with P/N and B/N as per Dwg using a permanent fine point marker, then Stock

Location: ST 72

AS 08/05/20 (46)

11.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-05-21

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN	RF	DRAWN BY	RF	DART AEROSPACE LTD
				HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	DRAWING NO. D3151
				REV. C SHEET 1 OF 1
DATE	05.12.07	TITLE	DOUBLER ASSEMBLY	SCALE 1:4
A	02.04.23	NEW ISSUE		
B	04.09.08	RE-DESIGN		
C	05.12.07	REVISE NOTES		

MS20426AD3-3 RIVET (1)
(6 PLACES)

MS21059L08 NUTPLATE (1)
MS20426AD3-4 RIVET (2)
(2 PLACES)

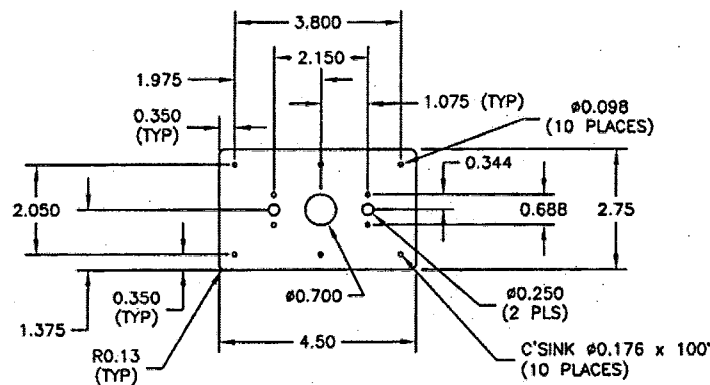
D3151-3

D3151-1

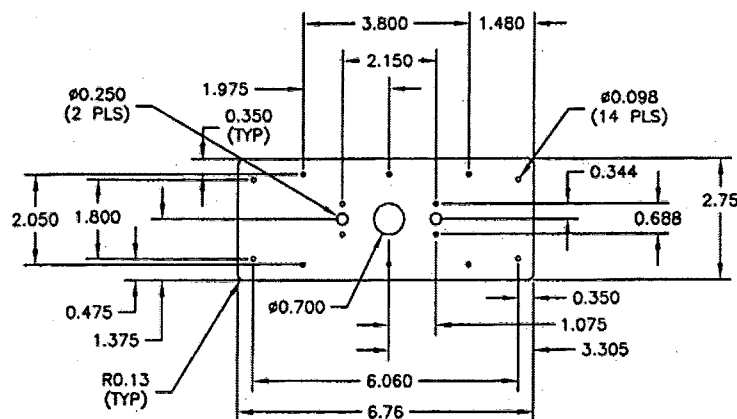
D3151-041 DOUBLER ASSEMBLY
REPLACES PREMIER P/N B30-23000-173/-174

RELEASED

05.12.07 *[Signature]*



D3151-1



D3151-3

NOTES

- 1) MATERIAL: 2024-T3 SHEET (QQ-A-250/4) 0.040" THICK (REF. DART SPEC. M2024T3S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010
- 6) IDENTIFY WITH DART P/N D3151-041 USING FINE POINT PERMANENT INK MARKER

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *39184*

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